

NON-EUROCOPTER

Work Order ID 58144

April 26, 2010 11:38:33 AM

Page 1

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002
Attn: NON -EUROCOPTER

I put Label in steps 8.1.1/06

8 10/05/06

HJ 42 BG 10/05/06

110

0.00

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/R Aluminum Rod M1006330

3-Grind End Plate flush

10.04.28

4 P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58144

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Page 2

Item ID: D350-591-312

Accept

Setup Start

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Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____





Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00							(9) 10.04.29
130  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							(9) 10.04.29
140  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							4 10.04.29


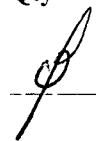



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Page 3

Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long RH					
Start Date:	4/26/10	Start Qty:	4.00		Cust Item ID:	
Required Date:	5/03/10	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		SAD 10-04-29		4			
180  Large Fab Large Fab	Large Fab Memo 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R [] Aluminum Rod [] M112860 6-Grind End Plate flush 7-Install last rivet as per Dwg.	0.00 0.00				4			

Work Order ID 58144

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Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10 Start Qty: 4.00

Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00		D		(4) 10.05.04			
200  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 10/05/04					(K4 RH) 10-5-4
210  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							




Work Order ID 58144

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Item ID:	D350-591-312	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step, Long RH				Stop	
Start Date:	4/26/10	Start Qty: 4.00		Cust Item ID:		
Required Date:	5/03/10	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M114207</i> Memo START TIME: <i>10:00AM</i> OVEN TEMPERATURE: <i>320°F</i> FINISH TIME: <i>10:30AM</i>	0.00 0.00		<i>=> M 10/05/05</i>		<i>X4</i>	<i>Ø</i>		
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M113545</i> Memo	0.00							<i>④ RH 10-5-5.</i>
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>=> M-H 10/05/05</i>					<i>④ RH</i>

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Item ID: D350-591-312

Accept

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10 Start Qty: 4.00

Required Date: 5/03/10 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

MUP

Accept (Signature)

14 RH (Signature)

Accept (Signature)

Work Order ID 58144

Page 7

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Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10 Start Qty: 4.00



Cust Item ID:

Required Date: 5/03/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/06

JMR 10-5-6

Picklist Print

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Page 1

Work Order ID: 58144

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

AN3-35A 28 Purchased No 260 250 M Each 64.0000 8.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST353 64

112314 14

114382 50

AN4-13A 84 Purchased No 260 250 M Each 91.0000 32.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST357 91

114181 6

114330 28

114416 50

4828 7

AN5-36A 28 Purchased No 260 250 M Each 149.0000 8.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST341 149

114292 149

M112314

M114498

M114292

Ce 14/5/6 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 11:38:20 AM

Work Order ID: 58144



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

S ₄	AN960JD10	148 NA 51179 23635	Purchased	No	260 250 AA	Each	0.0000	16.0000	-	114292	Ch
	Washer										
S ₄	AN960JD416	148 NA 51149 24435	Purchased	No	260 250 AA	Each	0.0000	64.0000	-	114576	Ch
	Washer										
S ₄	AN960JD516	148 NA 51149 25635	Purchased	No	260 250 AA	Each	0.0000	16.0000	-	1113706	Ch
	Washer										
S ₄	D2230-3	44	Manufactured	No	260 250 AA	Each	101.0000	16.0000	-		Ch
	Lug										

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST476

101

56855

101

Manufactured No

Each

133.0000 8.0000

56855

Le 14576 8

S ₄	D2618	24									
	Bushing										

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST020

133

56892

33

57829

100

56892

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 11:38:20 AM

Work Order ID: 58144



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 104.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D2856-400 Manufactured No



Abraison Strip

S H
207.20
messing
Sidostoc

260
250 M

302.9400 2.4000



CE

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

302.94

50593

86.94

56626

216

Each

38.0000

4.0000



50593

10.04.30

D3065-041 Manufactured No



Step Leg Assembly Hi

407.20

180 M

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

38

55450

8

56827

30

Each

32.0000

8.0000



4

10.04.30

D3066-1 Manufactured No



Spacer

180 M

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

32

56752

32

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 11:38:21 AM

Work Order ID: 58144



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A104.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D3067-1 Manufactured No 110 Each 17.0000 4.0000



End Plate



10.04.28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 357926 17
57011 17

3
1

D3067-1 Manufactured No 170 ²⁶⁰ Each 17.0000 4.0000



End Plate



10.04.28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 357926 17
57011 17

4

D3219-1 Manufactured No 150 ¹⁸⁰ Each 61.0000 8.0000



Plate



10.04.28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 61
56826 61

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 11:38:22 AM

Page 5

Work Order ID: 58144

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

D3235-1 ⁵² Manufactured No ²⁰⁰ Each 23.0000 8.0000



Mounting Lug

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST471

23

55315

23

D3272-1 Manufactured No 110 Each 12.0000 4.0000



Step

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

B58145

12

57848

12

D3278-041 ¹⁴¹ Manufactured No ²⁰⁰ Each 23.0000 4.0000



Support Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST471

23

55318

23

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 26, 2010 11:38:22 AM

Page 6

Work Order ID: 58144

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A[104.03.22]New issue [KJ/RF]

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:c

DS19410-011

Manufactured No

250 AD

Each

2.0000

1.0000



Step Modification

change 1

58409 4/14/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

57038

2

MS20600-AD4W4

Purchased

No

180
180 AD

Each

863.0000

64.0000



Rivets

10.04.30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST321

863

113368

363

114181

500

MS21042L3

Purchased

No

260
250 AD

Each

996.0000

8.0000



Nut

14/5/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

996

113537

46

113644

950

M113644

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 58144



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Start Date: 4/26/10

Required Date: 5/03/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

MS21042L4

88

Purchased

No

260

Each

1,306.000 32.0000



Nut

250 M



Handwritten signature

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST139

2

111827

2

Main Warehouse

ST300

804

113422

112

114108

684

9063

8

Main Warehouse

ST463

500

114416

500

MS21042L5

28

Purchased

No

110

Each

822.0000 8.0000



Nut

250 M



114416 58

Handwritten signature

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

822

113523

26

113537

100

114108

196

114437

100

114449

400

1144108

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>QD</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

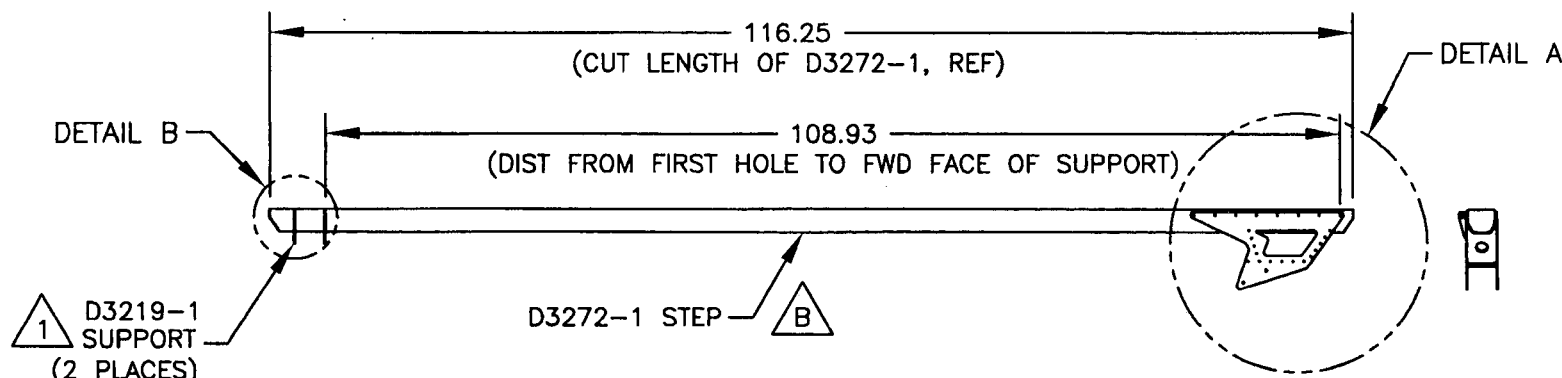
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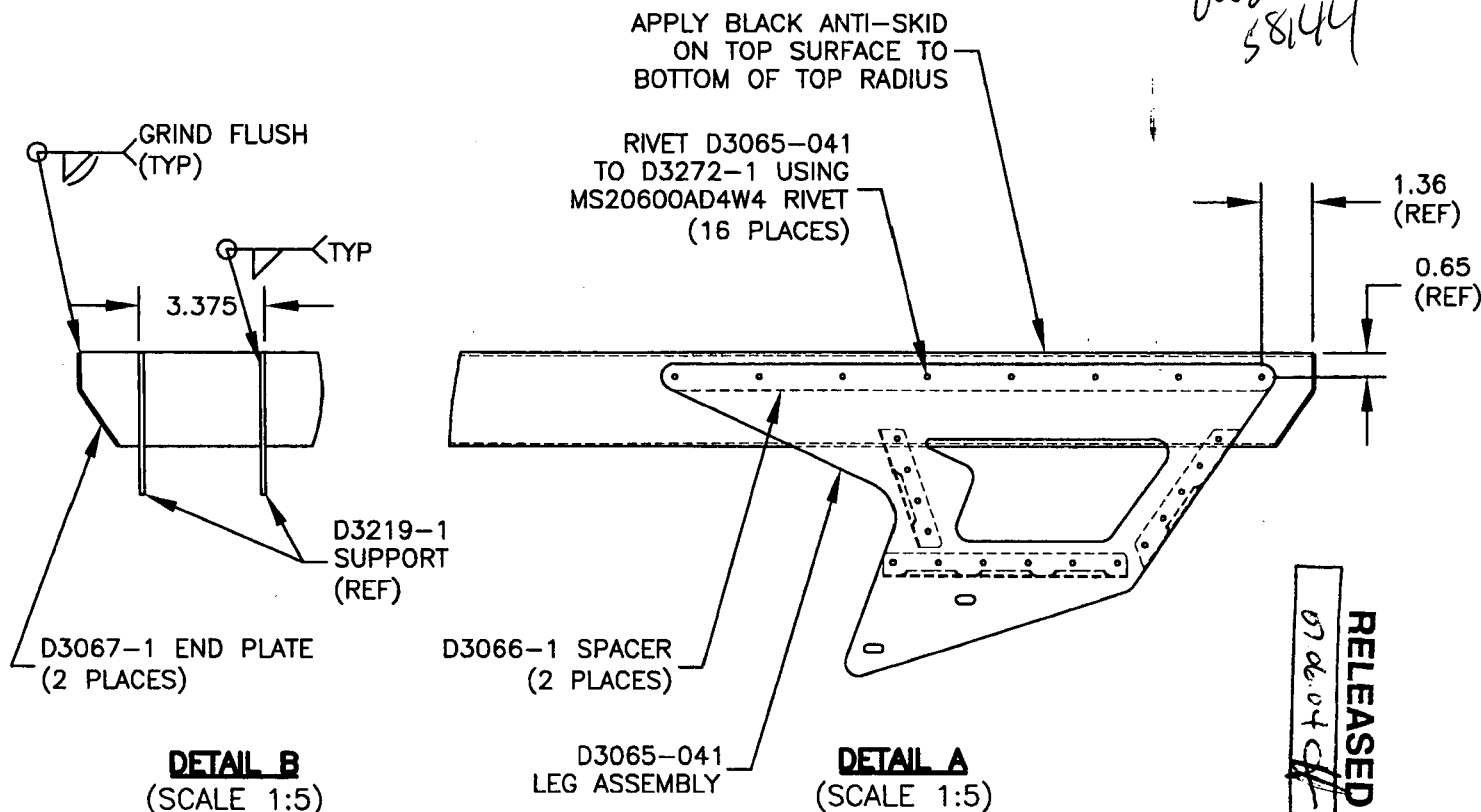
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DART

DESIGN	40	DRAWN BY		DART AEROSPACE LTD
CHECKED	LE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	

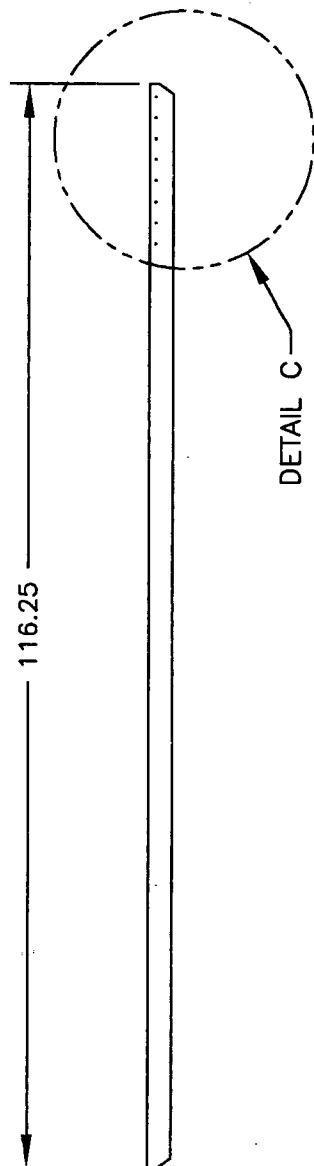


D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



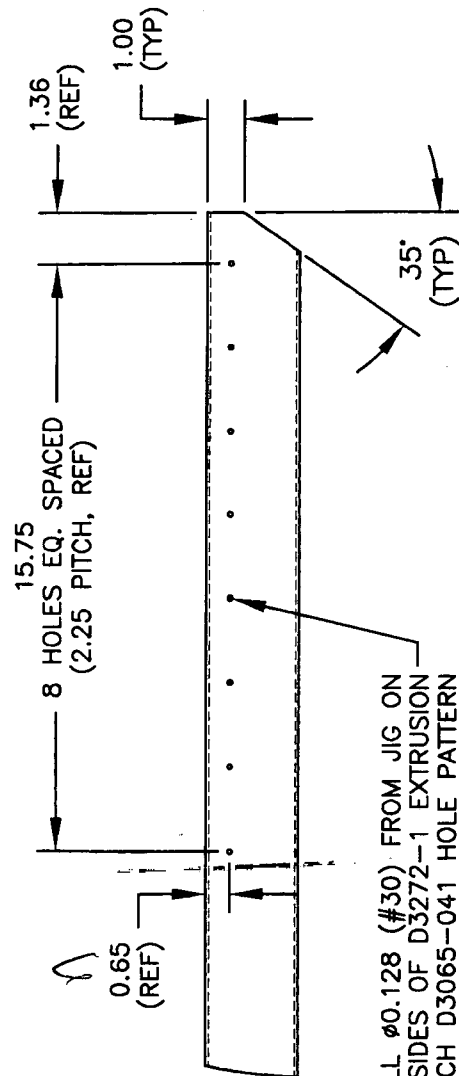


DESIGN <i>gp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)

WLD 5/24/4



DETAIL C
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries